

**\*97774\***

February-22-13 11:13:17 AM

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

**Cust Item ID:**

**Customer:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

P10

W/O: 97774		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
13/02/22	105	DO NOT DRY MAT.	DL	13/02/22	2.	MP 13/2/22	

Part No: D4758-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 97774

February-22-13 11:13:17 AM

**\*97774\***

Page 3

Item ID: D4758-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Blanking Plate

Start Date: 2/22/13

Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/22/13

Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*150\***

QC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

2 *Wh* 13/02/22

15  
9-89

13222

2

013/2/22 2

**Work Order ID 97774****\*97774\***

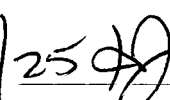
Page 4

February-22-13 11:13:17 AM

Item ID: D4758-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Blanking Plate  
Start Date: 2/22/13      Start Qty: 2.00      **\*2\***      Cust Item ID:  
Required Date: 2/22/13      Req'd Qty: 2.00      **\*2\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

13/2/25 

u 13-02.22

# Picklist Print

February-22-13 11:13:17 AM

Page 1

Work Order ID: 97774

Parent Item: D4758-1

Parent Item Name: Blanking Plate

Start Date: 2/22/13

Required Date: 2/22/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 13/01/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02 GE PLASTICS LEXAN SHEET		Purchased	No				sf	629.5360		2.1052632			

Location

Loc Qty

Loc Code

therm

110877

122033

629.5360009

31.0000009

598.536

2.10

13/02/22

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 97774
<b>Description:</b> BLANKING PLATE		<b>Part Number:</b> D4758-1
<b>Inspection Dwg:</b> D4758	<b>Rev:</b>	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> JB	<b>Date:</b> 13/02/22
------------------------	-----------------------

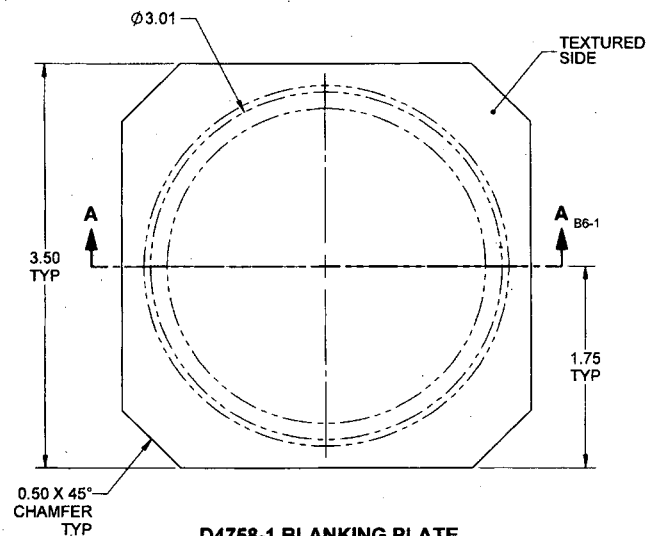
**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.093	REF	.0925	✓			
3.50	TYP	3.59	✓			

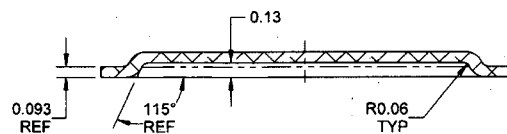
<b>Measured by:</b> JB	<b>Date:</b> 13/02/22
<b>Audited by:</b> wh	<b>Date:</b> 13/02/22
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

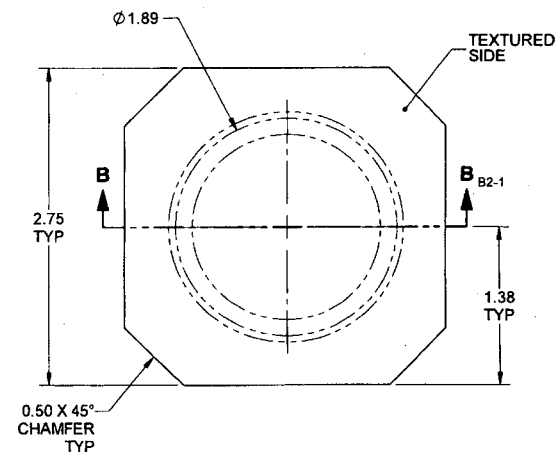
10.04.14



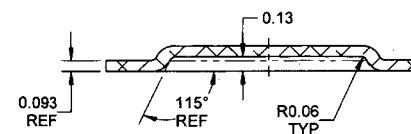
**D4758-1 BLANKING PLATE**



**SECTION A-A C6-1**



**D4758-3 BLANKING PLATE**



**SECTION B-B B2-1**

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET, 0.093 THICK  
REF. DART SPEC. MLEXS.093-F6006-02
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4758-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
- 7) WEIGHT: - D4758-1 = 0.05 lbs; D4758-3 = 0.02 lbs
- 8) TOOLING: - D4758-1: THERMOFORM PER MOLD DT9872 PER QSI 022  
- D4758-3: THERMOFORM PER MOLD DT9873 PER QSI 022

*al697774*

**RELEASED**  
2013-01-14

A NEW ISSUE		MB 12.12.07	
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.12.07		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4758** REV. A  
SHEET 1 OF 1

TITLE **BLANKING PLATES** SCALE NTS

COPYRIGHT © 2012 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.